Work Order ID 61025

August 4, 2010 9:58:37 AM

Item ID: D412-698-031 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Cabin Door Roller, LH

Start Date: 8/04/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/11/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** M **Date:** 10-8-09 **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
IIN D412-698 / Rev E									
100	DOCUMENT CONTROL	0.00					M 10-8-09		
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-698-031				CHG001				
		8/10/08/09							
110	Pick Kit	0.00					10/8/09		
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control		8/10/08/09							

NOTE: Date & Initial

H:\FORMS\Quality Assuranc

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

all entries

e\approved QA\NCRWO RevE

Work Order ID 61025

August 4, 2010 9:58:37 AM

Item ID: D412-698-031 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Cabin Door Roller, LH

Start Date: 8/04/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/11/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Packaging					10/8	9	SL	P
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPP D412-698-031 ☐Location: 62 ☐PPP Rev: A								
140	QC21- Final Inspection - Work Order Release	0.00						10/08/09	
QC	**Memo**	0.00							
Quality Control								MF 10-8-9	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

August 4, 2010 9:58:41 AM

Work Order ID: 61025

Parent Item: D412-698-031

Parent Item Name: Cabin Door Roller, LH

Start Date: 8/04/10 **Required Date:** 8/11/10

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-143 Bracket Assembly		Manufactured	No			120	Each	4.0000	1	1	10/8/9 SP		
				Location		**Loc Qty**		**Loc Code**					
				ST235A		4							
					58767	4							
D3137-043 Bracket Assembly		Manufactured	No			120	Each	7.0000	1	1	10/8/9 SP		
				Location		**Loc Qty**		**Loc Code**					
				ST235B		7							
					42192	1							
					59916	6							
D3183-043 Bracket Assembly		Manufactured	No			120	Each	3.0000	1	1	10/8/9 SP		
				Location		**Loc Qty**		**Loc Code**					
				ST236		3							
					54759	3							
D3202-3 Cover		Manufactured	No			120	Each	9.0000	1	1	10/8/9	SP	
				Location		**Loc Qty**		**Loc Code**					
				ST241A		9							
					52284	9							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

August 4, 2010 9:58:41 AM

Work Order ID: 61025

Parent Item: D412-698-031

Parent Item Name: Cabin Door Roller, LH

Start Date: 8/04/10 **Required Date:** 8/11/10

Start Qty: 1.00 **Required Qty:** 1.00

D3674-041	Manufactured	No	120	Each	13.0000	3	3	10/8 9 SP
BRACKET ASSEMBLY								

Location	Loc Qty	Loc Code
ST236A	13	
42514	13	3

D3675-1	Manufactured	No	120	Each	37.0000	9	9	10/8/9 SP
SLIDING DOOR BRACKET								

Location	Loc Qty	Loc Code
ST236A	37	
52168	37	9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS
(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						**D412-698-019**	**BEARING OVERHAUL KIT**
	X					**D412-698-021**	**REPLACEMENT SHIM KIT**
		X				**D412-698-031**	**CABIN DOOR ROLLER KIT, LH**
			X			**D412-698-032**	**CABIN DOOR ROLLER KIT, RH**
				X		**D412-698-033**	**REPLACEMENT DOOR TRACK KIT**
					X	**D412-698-035**	**DOOR HANDLE KIT**
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.